

Date: Wednesday, 11/03/2009 7:17:05 AM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 46403 -3

Estimate Number : 12884

P.O. Number :

This Issue : 11/03/2009

S.O. No. :

Prsht Rev. : NC

First Issue : 11

Previous Run : 44474

Type : MACHINED PARTS

Drawing Name : ARM

Part Number : D3560044

Drawing Number : D3560 REV D

Project Number : N/A

Drawing Revision : D

Material :

Due Date : 18/03/2009

Qty: 10 Um: Each

Written By :

Checked & Approved By :

Comment :

Est Rev:A New Issue 07.05.24 EC

Est Rev B ECN 987 07.19.09 EC

Est Rev:C ECN1048 07-12-18 DD verified by: EC

verified by DD

verified by: EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X05000

6061-T6 Bar .500 x 5.00



Comment: Qty.: 1.3598 f(s)/Unit Total: 13.5975 f(s)
 6061-T6 Bar 0.50" x 5.00"

Batch:

1110167 x 8
 1110550 x 4.6
 1110536 x 16

mf 07/03/15

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long



3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1



1- Mill as per Folio FA696 Rev: A4 & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-044 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: P Date: 01/04/15
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 46403

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/04/15	30	4 parts have 0.261" core 0.27" core ^{rec} need to be 2 parts are at 0.261" deep 2 parts are at 0.275" deep EC	UP 09/03/16 per 01/04/15	0.261" DEEP ACCEPTABLE 0.275" SCRAP Qty x 2 no rep/scr	nme 09/03/16	09/03/16	UP 09/03/16 per 01/04/15	S 01/04/16

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 7:17:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 46403

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

CRK 09/03/11

(8)

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE *347015*

09-06-04 2

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *h*
- 2- set up bracket and arm on jig *h*
- 3- preheat bracket and arm with torch *h*
- 4- clean before welding with brush *h*
- 5- set up machine to 135 amps *h*
- 6- weld across bottom and top ends *h*
- 7- reheat with torch (65 deg C) *h*
- 8- on one side weld from bottom to top half way *h*
- 9- same for other side (half way) *h*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *h*
- 11- same for remaining side (ease off pedal near end) *h*

09-06-04 2

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/09/06/09 (12)

PD 09-06-09 (2)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-06-09 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 7:17:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 46403

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 065 4.1

BR 09-06-10 *09-03-10*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-10

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch:

342181 *B41708*

09-06-10

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

09-06-10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-10

15.0

PACKAGING-1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W4*

Pat Evans

09-06-10

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09-06-10

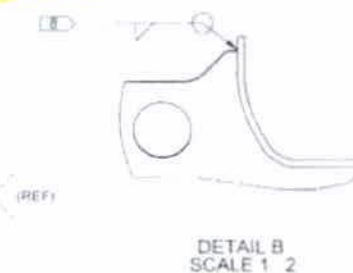
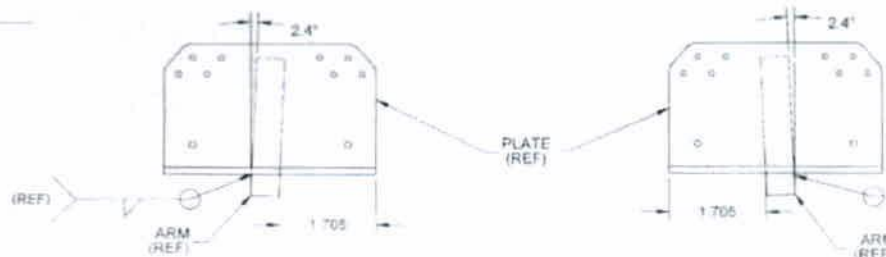
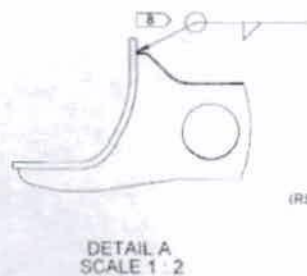
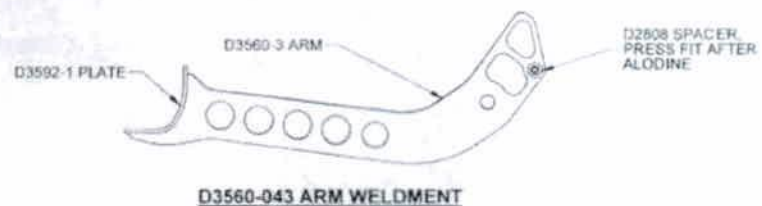
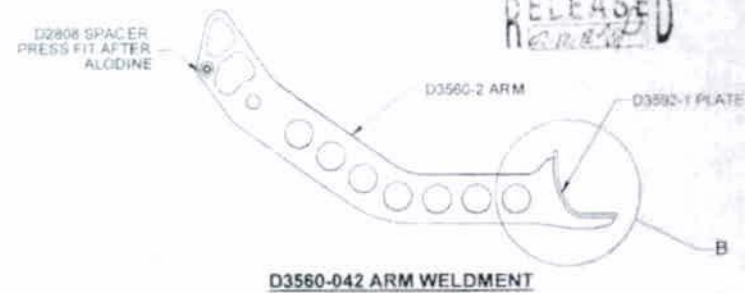
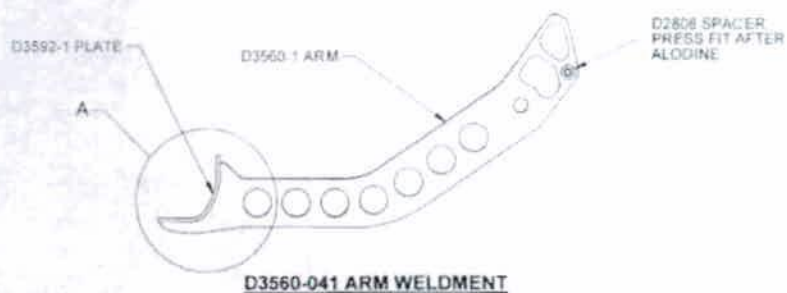
09-03-10

Job Completion



WLF
09-06-10

RELEASED



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

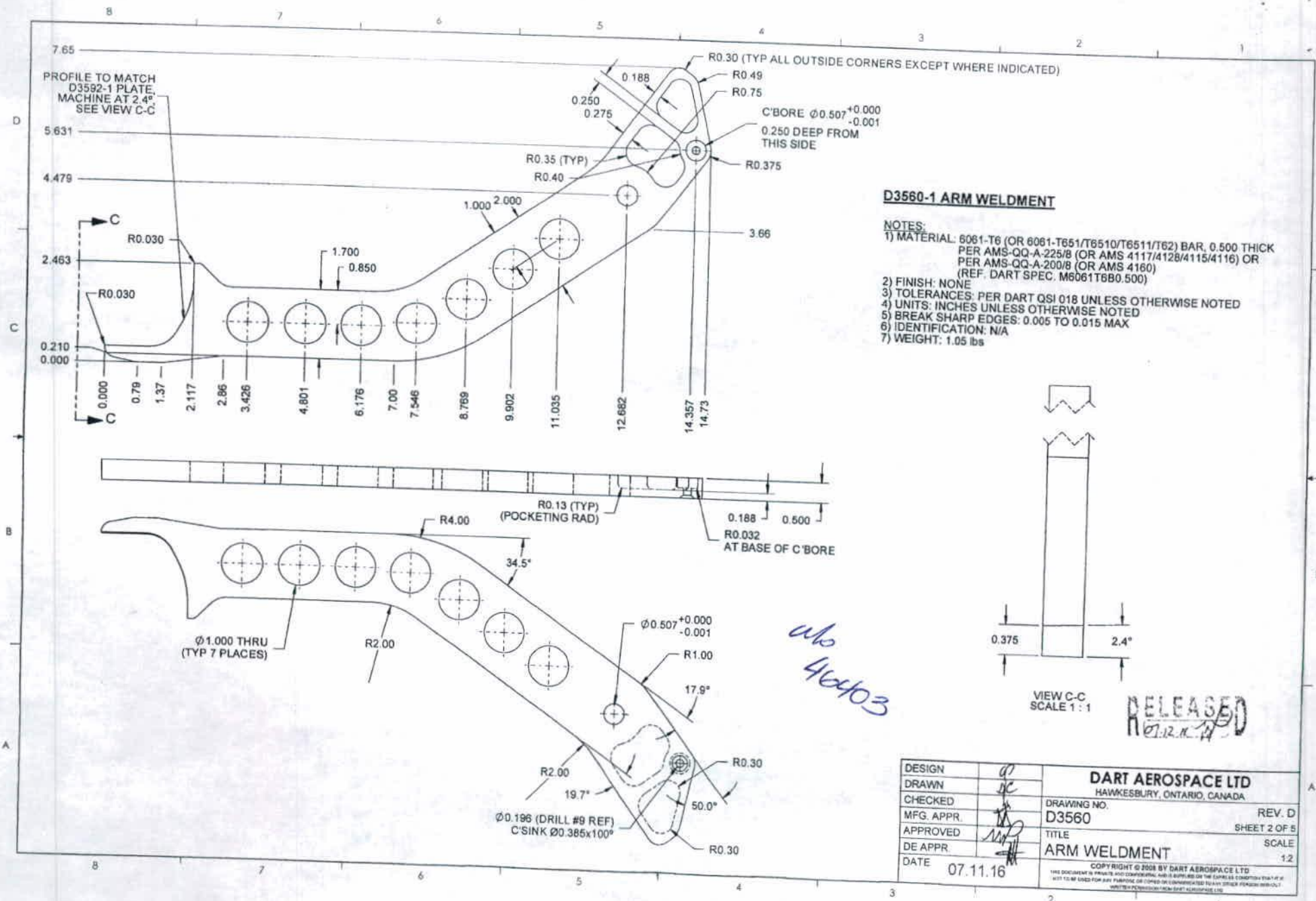
NOTES

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4-1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

DESIGN	ADD D2808 PRESS FIT NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.16
CHECKED	REDESIGN AS WELDMENT, ADD POCKET TS	CP	07.01.15
MFG. APPR	NEW ISSUR	CP	06.09.15
APPROVED		BY	DATE
DATE	07.11.16		

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO	REV D
D3560	SHEET 1 OF 1
TITLE	SCALE
ARM WELDMENT	1:4

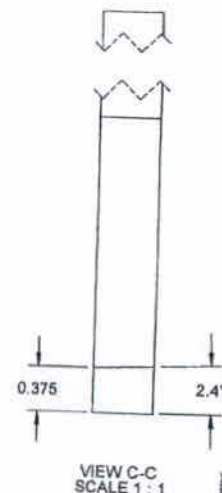
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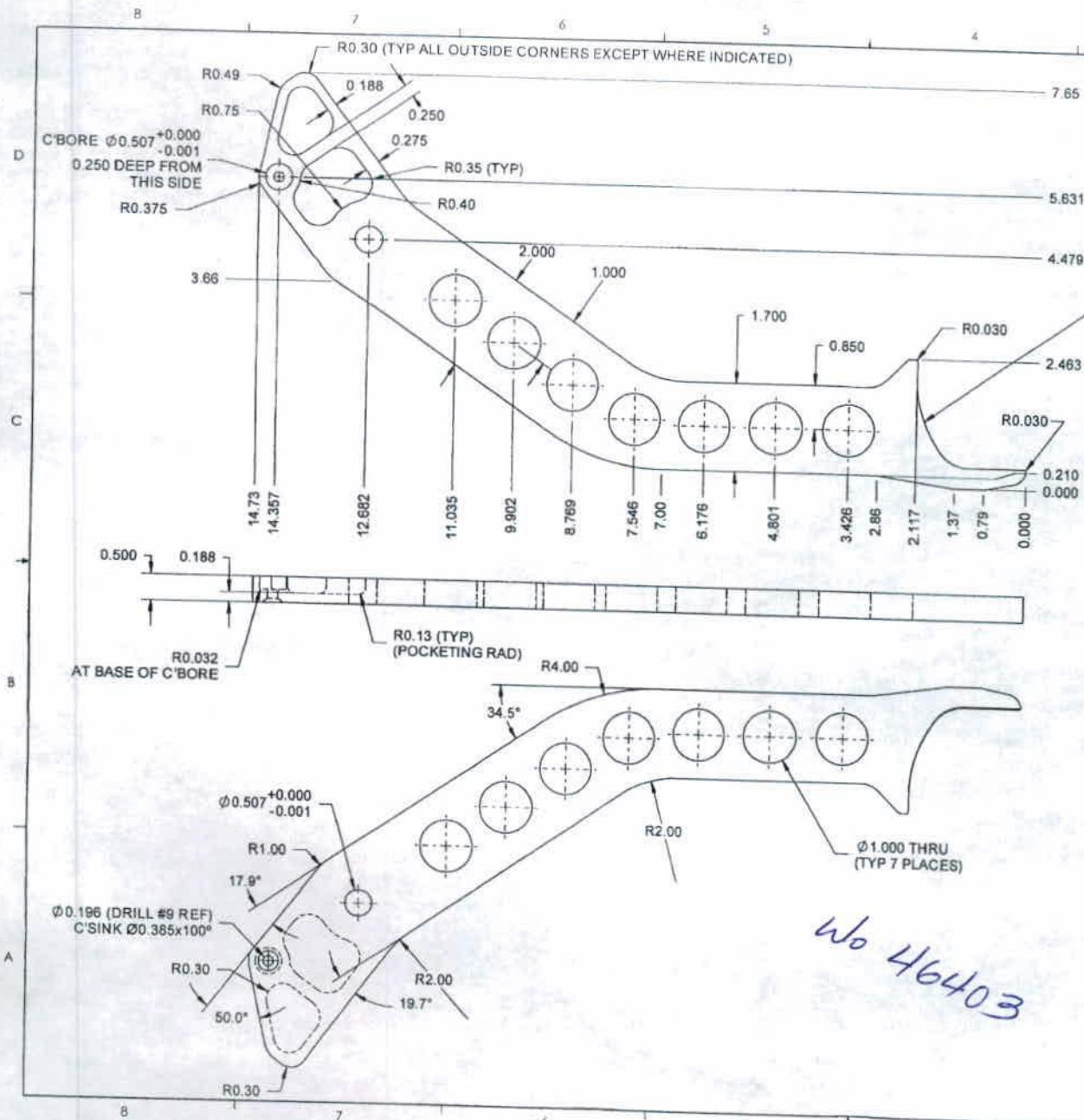
D3560-1 ARM WELDMENT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



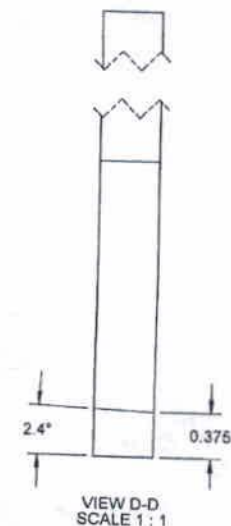
46403



PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°,
SEE VIEW D-D

D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M8061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



Wb 46403

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3560
MFG. APPR.		REV. D
APPROVED		SHEET 3 OF 5
DE APPR.		TITLE ARM WELDMENT
DATE	07.11.16	SCALE 12

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